

Date: Monday, 06/10/2008 10:44:56 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY
Job Number	: 42443		
Estimate Number	: 11527		
P.O. Number	:	Part Number	: D3021041
This Issue	: 06/10/2008 S.O. No. :	Drawing Number	: D3021 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37873	Material	:
Written By	:	Due Date	: 30/10/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUL 08.10.06</u>		
Comment	: Est. 01.10.23 New Issue SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
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Comment: Qty.: 2.1875 f(s)/Unit Total : 2.1875 f(s)

4130 Tube .750 OD x.049W

Cut- AISI 4130N tube, Ø3/4" x 0.049" wall batch: M10498

08/11/04

2.0	D301711	cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cap

batch: B42354

08/11/04

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3--Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: M10226

08/11/04

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

BE 08/11/06 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 10:44:56 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 42443

Part Number: D3021041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8081106 (X)

6.0

POWDER COATING

POWDER COATING



M 106442



(IX)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:40
320 °F
4:10

MF 08/11/06

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-07

(X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P0042416

85 08/11/07 (X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/10

Job Completion



MF 08-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

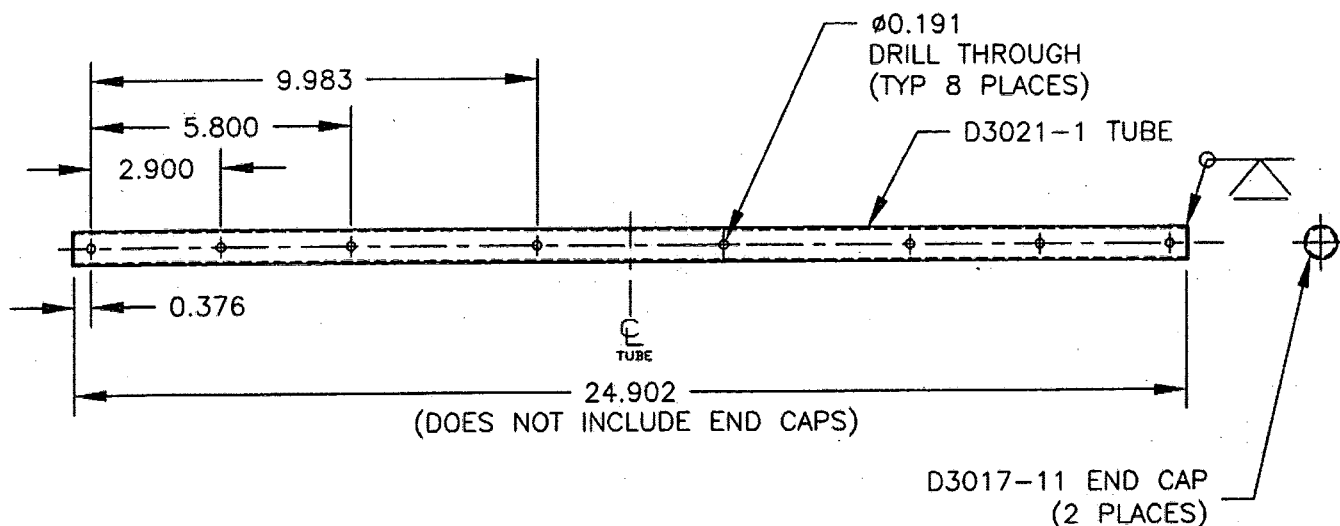
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 42443

RELEASED
01.05.309

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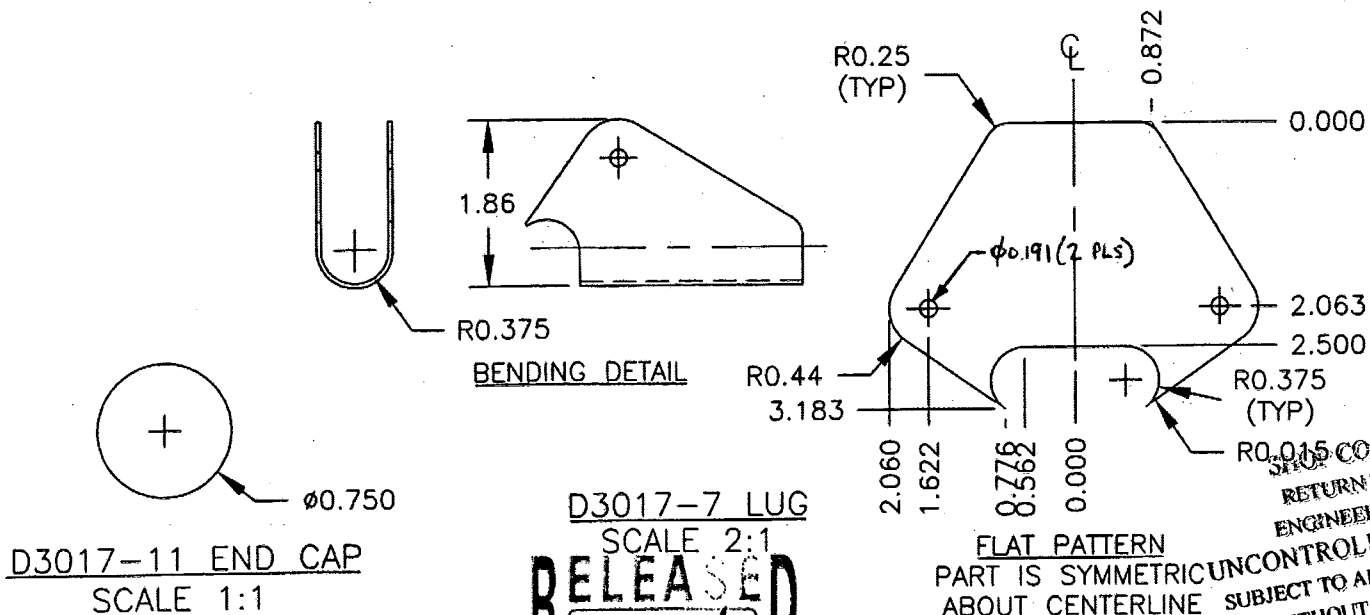


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18	TITLE BACK FRAME ASSEMBLY	SCALE 1:1	
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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